

532

| | | |
|----------------------------|--------------|-------|
| DART AEROSPACE LTD | Work Order: | 23860 |
| Description: Rappel Anchor | Part Number: | D2224 |
| Drawing: D2224 Rev. E | Qty: | 5 |

| Step | Location | Procedure | By | Date | Qty |
|------|------------|--|-----|----------|-----|
| 1 | EXPEDITING | Open W/O | SP | 05/07/25 | 5 |
| 2 | METAL | Cut blanks: 2.660" +.030" / -.010" Note grain direction Material: 7075-T7351 or 7075-T651, 2.5" X 3.2" Batch _____ | | | |
| 3 | HAAS | Machine as per Folio D2224 | | | |
| 4 | QC | Inspect Level 2 | | | |
| 5 | QC | Inspect Level 8 | | | |
| 6 | METAL | Tumble Deburr any rough edges after tumbling | | | |
| 7 | QC | Inspect Level 5 | CMC | | |
| 8 | PURCHASING | Issue P/O: _____ Red Anodize | | | |
| 9 | QC | Inspect Level 3 | | | |
| 10 | STORES | Bag and Tag | | | |
| 11 | EXPEDITING | Close W/O Inspect level 21 Cost / Part: 0 Sat 05/08/02 | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---|------------|----------|
| A | 97.05.16 | New Issue | | |
| B | 93.10.22 | Red Anodize, inspection level, drawing revision | KS | |
| C | 99.05.06 | New material, Re-format | DM | |
| D | 02.04.23 | Add note for grain direction & inspect 8, 21 | NG | 02.04.26 |

RELEASED

02/04/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

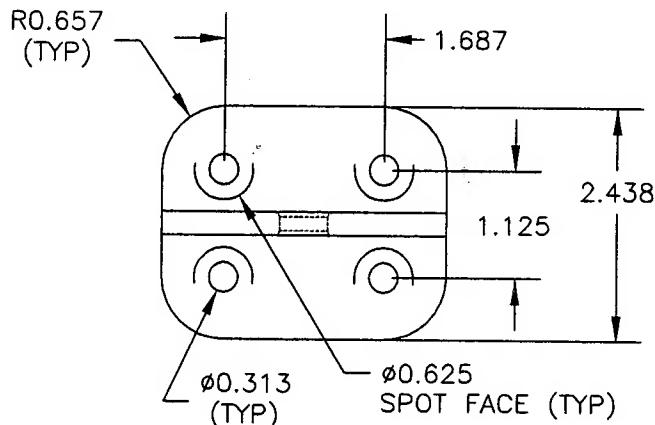
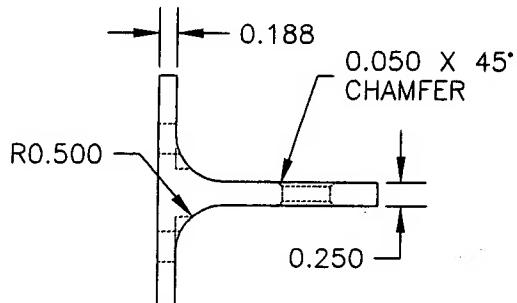
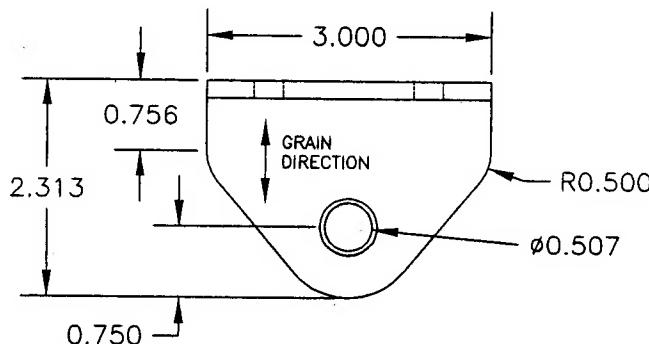
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART

| | | |
|------------------------------|--------------------------------|---|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>RF</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>KE</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2224 |
| DATE 99.04.29 | | REV. E SHEET 1 OF 1 SCALE 1:2 |
| A | 94.03.10 | NEW ISSUE |
| B | 95.04.11 | D2227 WAS D2216 |
| C | 96.06.17 | ADDED D2224-60 |
| D | 97.04.25 | CHANGE TO T-SHAPE |
| E | 99.04.29 | REVISE MATERIAL SPECIFICATIONS |

RELEASED
99.09.11 KE

SHOP DRAWING
REVISION C
ENGINEERING
UNCONTROLLED
SUBJECT TO ALL
WITHOUT NC1
WORK ORDER
NO. _____



MATERIAL: 7075-T7351 (QQ-A-200/11) OR 7075-T651 (QQ-A-200/11)
 FINISH : ANODIZE RED PER MIL-A-8625
 BREAK ALL UNMARKED EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jul 22, 2005
07:41 am

Work Order No : 0023860
 Project Name : D2224
 Project For : WK532
 Work Order Type : Main
 Main WO Number :
 House Part Number : D2224
 Description : Rappel Anchor Assembly
 Manufactured : Yes
 Amount Req'd : 5
 Amount Done : 0
 Start Date : 07-21-05
 Est Finish Date :
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd :

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00
 Order Entry No :
 OE Value : 0.00
 Est Mark Up : 0.000%
 Actual Mark Up : 0.000%
 \$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/ (Loss) : | 0.00 | 0.00 |